DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-015537 Address: 333 Burma Road **Date Inspected:** 09-Jul-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Gao Zhi Chun **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** Tower & OBG Components

Summary of Items Observed:

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY SOUTH TOWER LIFT-2&3

This QA Inspector carried out the dimensional verification on East Tower lift-2 & 3 to check the misalignment and gap between the interior splice plates and longitudinal stiffeners of skin 'A', 'B', 'C', 'D' & 'E'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #4B located on South tower Lift-5 SSD1 – TL5 – 1E/F. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3213 - TC - U5b.

Weld joint #4B located on Lift-5 Splice Plate Stiffener SSD1 – SPSA5 – 13. Welder is identified as 052493. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1.

Weld joint # 3A located on Lift-5 Splice Plate Stiffener NSD1 – SPSA5 – 13. Welder is identified as 050289. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #2A located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 7. Welder is identified as 046709. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1.

Weld joint # 3A located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 12. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1.

Weld joint # 3A located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 12. Welder is identified as 040614. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1.

Weld joint #1A located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 20. Welder is identified as 040667. ZPMC Quality Control (QC) Inspector is identified as Liu Dao Feng. The welding variables recorded by QC appeared to comply with the WPS -B - T - 3211 - Tc - U5b - 1.

ORTHOTROPIC BOX GIRDER (OBG) LIFT-13 AT BAY#11

This QA Inspector observed the following work in progress

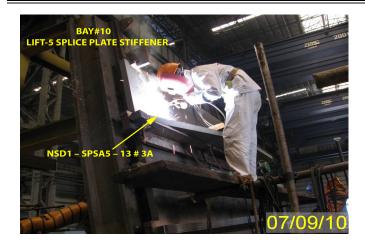
Fluxcored Arc Welding (FCAW):

Weld joint #32 located on Side Plate SP3106 – 001. Welder is identified as 049220. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS -B - T - 2132. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)





Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer